

Work Order ID 144788

Monday, April 25, 2016 7:19:47 AM

144788

Page 1

Item ID: D135-692-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: EC135 Bearpaws

Start Date: 4/25/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 4/26/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MJS

Date: **APR 22 2016**

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3049	A1
IIN-D135-692	B

MJS

Mha 16-04-25

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D135-692-011 CHG002

5 DAS 28 9-59

MAY 24 2016

(5)

150

Pick Kit

0.00

150

Packaging

Memo

0.00

Packaging

5 DAS 27 9-59

DAS 27 9-59

APR 25 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC4- 100% Inspect kits for completeness	0.00							
160						5	DAS 28 9-89	MAY 24 2016	
QC	Memo	0.12							
Quality Control									
170	Packaging	0.00							
170						5x	DAS 28 9-89	DAS 27 9-89	MAY 24 2016
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D135-692-011								
	Location: <u>2X sold</u>								
	PPP Rev: <u>3X Fg 013</u>								
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.40							
Quality Control									

MCS MAY 24 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																				
OTHER : ☐																									

Picklist Print

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Page 1

Work Order ID: 144788

144788

Parent Item: D135-692-011

D135-692-011

Parent Item Name: EC135 Bearpaws

Start Date: 4/25/2016

Required Date: 4/26/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:C04.02.17Blank size changed, Tolerance added Step
3KJ/JLM IPP REV:E AS PER DSI
9592/9587 REV A JLM VERIFIED BY:EC
IPP Rev:D 08-04-16 Added Step 2 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-13A		Purchased	No				Each	327.0000		8 32 40			
AN4-13A									**				
Bolt													

Location Loc Qty Loc Code

FG	20	
122808	20	
GA	37	
m134167	37	
ST344	270	
m134260	9	
m134497	261	

D2182B		Manufactured	No				f	449.9593	2	8 10			
*D2182B*060									**	130681			
Rubber Cushion - Black (\$Per Foot)													

Location Loc Qty Loc Code

ST411	449.9593	
130427	99.9593	
135093	350	

(D2182B060) Cut 4 at 6.00"

APR 25 2016

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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Parent Item: D135-692-011

D135-692-011

Parent Item Name: EC135 Bearpaws

Start Date: 4/25/2016

Required Date: 4/26/2016

Start Qty: 4.00

Required Qty: 4.00

D2274

Manufactured No

160

Each

113.0000

8

D2274

Radius Block

**

32 40

144391

88 9 8

DAS 27 9-89

Location

Loc Qty

Loc Code

FG

12

86855

12

ST006

101

141052

101

D2519

Manufactured No

160

Each

12.0000

4

D2519

Clamp

**

16 20

145439X8

88 9 8

DAS 27 9-89

Location

Loc Qty

Loc Code

ST542

12

140057

12

D2529

Manufactured No

160

Each

628.0000

8

D2529

Washer

**

32 40

88 9 8

DAS 27 9-89

Location

Loc Qty

Loc Code

ST008

500

143819

500

ST009

128

141458

128

D3049-1

Manufactured No

160

Each

2.0000

2

D3049-1

Bearpaw

**

16 10

144343X88

88 9 8

DAS 27 9-89

Location

Loc Qty

Loc Code

ST454a

2

139972

2

DAS 28 9-89

APR 25 2016

2

DQA: _____ Date: _____



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Page 3

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Parent Item: D135-692-011

D135-692-011

Parent Item Name: EC135 Bearpaws

Start Date: 4/25/2016

Required Date: 4/26/2016

Start Qty: 4.00

Required Qty: 4.00

MS21042L4

Purchased

No

160

Each

2,054.000

8

32 40

MS21042L4

Locknut

**

DAS 27
6 9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

288

m133769

288

ST303

1669

m134055

1

m134502

168

m134509

500

m134606

1000

ST305

97

m130922

97

NAS1149D0463J

Purchased

No

160

Each

2,824.000

8

32 40

NAS1149D0463.J

WASHER

**

DAS 27
6 9-89

APR 25 2016

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

342

M132035

21

M134508

321

ST260a

600

M134508

600

ST263

894

M134039

29

M134573

865

ST269

988

M132317

100

M132677

888

Monday, April 25, 2016 7:19:50 AM

Shop Packet Print

Page 3

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D135-692-011

Parent Item Name: EC135 Bearpaws

Start Date: 4/25/2016

Required Date: 4/26/2016

Start Qty: 4.00

Required Qty: 4.00

QS100-M24S

Purchased

No

160

Each

25.0000

4

T6 20

QS100-M24S

Clamp

DAS
28
9-89

Location

Loc Qty

Loc Code

ST545

25

m133931

15

m134606

10

46 15
3

APR 25 2016

DAS
28
9-89

DQA: _____ Date: _____



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Misidentified ☐	Past Due ☐																																																																

DAS
28
9-88

4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D135-692-011	11.8 lb	0.0 in	0.0 in-lb	199.7 in	2356 in-lb
<i>Bearpaw Installation</i>	5.36 kg	0.0 m	0.0 m-kg	5.07 m	27.2 m-kg
D135-692-041	2.24 lb	0.0 in	0.0 in-lb	199.7 in	447 in-lb
<i>Wearplate Kit</i>	1.0 kg	0.0 m	0.0 m-kg	5.07 m	5.1 m-kg
D135-692-011	11.8 lb	0.0 in	0.0 in-lb	201 in	2372 in-lb
<i>Bearpaw Installation, Aft Location</i>	5.36 kg	0.0 m	0.0 m-kg	5.10 m	27.3 m-kg
D135-692-041	2.24 lb	0.0 in	0.0 in-lb	201 in	450 in-lb
<i>Wearplate Kit, Aft Location</i>	1.0 kg	0.0 m	0.0 m-kg	5.10 m	5.1 m-kg

5. PARTS LIST

Qty -011	Qty -041	Part Number	Description
X		D135-692-011	BEARPAW INSTALLATION
	X	D135-692-041	WEARPLATE KIT
4		D2182B060	RUBBER CUSHION
8		D2274	RADIUS BLOCK
2		D3049-1	BEARPAW
8		D2529	WASHER
4		D2519	CLAMP
	2	D3719-041	WEARPLATE
8	8	AN4-13A	BOLT
8	8	NAS1149D0463J	WASHERS
8	8	MS21042L4	NUT (OR MS21042-4)
4		QS100M24S	CLAMP

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Revision: B

Date: 15.07.20